

Work Order ID 151682

151682

Page 1

Wednesday, October 05, 2016 3:09:28 PM

Item ID: D044-662-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: R44 Bearpaws - Large
 Start Date: 9/26/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 10/6/2016 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: OCT 06 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D044-662	E	OCT 18 2016 <u>DAS 6</u>					<u>DAS 21</u> 9-89	16-10-19	②
100	Document Control	0.00 <u>9-89</u>							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD044-662-013	CHG 002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

2x DAS 28
9-89 OCT 27 2016

2 DAS 6
9-89 OCT 19 2016

2x DAS 28
9-89 OCT 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																							
Description Work Order Deviation				Disposition																																																											
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

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Page 2

Item ID: D044-662-013

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: R44 Bearpaws - Large

Start Date: 9/26/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/6/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D044-662-013
LOCATION: FG0142X DAS
28
9-89

OCT 27 2016

140

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

0.03

DAS
21
9-89

OCT 27 2016

Quality Control

DAS
21
9-89

OCT 27 2016

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Misidentified ☐	Past Due ☐																																																																

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151682

D044-662-013

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-01-30 JLM
IPP Rev:B As per IIN 044-662 REV D 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4953-1 *D4953-1* Cushion		Manufactured	No			110	Each	0.0000	4	8			
D3601-1 *D3601-1* Radius Block		Manufactured	No			110	Each	45.0000	8	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST045		45							
				150996		1							
				151014		44							
D2529 *D2529* Washer		Manufactured	No			110	Each	395.0000	8	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST008		395							
				150996		395							
D3556-1 *D3556-1* R44 Bearpaw Clamp		Manufactured	No			110	Each	22.0000	4	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST542		22							
				148008		22							
D3529-1 *D3529-1* Bearpaw		Manufactured	No			110	Each	0.0000	2	4			

DQA: _____ Date: _____



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Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 151682

151682

Parent Item: D044-662-013

D044-662-013

Parent Item Name: R44 Bearpaws - Large

Start Date: 9/26/2016

Required Date: 10/6/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-15A

Purchased

No

110

Each

141.0000

4

8

AN4-15A

Bolt

**

DAS
6
9-89

DAS
27
9-89

OCT 19 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	26	
120449	26	
over003	100	
m135544	0	
m135774	100	
ST343	15	
m134055	1	
<u>m135470</u>	14	

NAS1149D0463J

Purchased

No

110

Each

2,684.000

8

16

NAS1149D0463.J

Washer

**

DAS
27
9-89

OCT 19 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	140	
M132035	5	
M134508	32	
M135056	103	
ST260a	1000	
M135767	1000	
ST263	1544	
<u>M135530</u>	544	
M135671	1000	

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 151682

151682

Parent Item: D044-662-013

D044-662-013

Parent Item Name: R44 Bearpaws - Large

Start Date: 9/26/2016

Required Date: 10/6/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-14A

Purchased

No

110

Each

232.0000

4

8

AN4-14A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	5	
122141	5	
over003	100	
M135671	100	
ST344	127	
M135390	27	8
M135407	100	

910Z 6 1 130

DAS
6
9-89

DAS
27
9-89

MS21042L4

Purchased

No

110

Each

1,688.000

8

16

MS21042L4

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001	34	
m133363	34	
GA	260	
m135058	260	
OVER007	1000	
m135704	500	
m135774	500	
ST303	394	
m135603	394	16

910Z 6 1 130

DAS
6
9-89

DAS
27
9-89

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OTHER : _____					

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.1 in 3.25 m	589 in-lb 6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb 2.81 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	129.1 in 3.28 m	800 in-lb 9.2 m-kg
D044-662-041 Wearplate Kit (installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb 0.73 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.3 in 3.26 m	205 in-lb 2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)